

Date: Wednesday, 21/05/2008 4:10:33 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 03.250 SUPPORT		
Job Number	: 39390		Part Number	: D29401		
Estimate Number	: 10387		Drawing Number	: D2940 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	21/05/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type : MACHINED PARTS	Due Date	06/06/2008	Qty:	20 Um: Each
Previous Run	: 38128					
Written By	:					
Checked & Approved By	: <u>JUL 08.5.21</u>					
Comment	: Est. C 02.11.26 Rerformat; Added P/O KJ Est Rev:C Added priming as per Rev B 07-04-30 JLM est E 08.03.19 Re-format Ec verified by DD					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DSK081	D2940-1 TURNING DETAIL	
		Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)	
		D2940-1 TURNING DETAIL	
		Batch: <u>B 38134</u>	<u>J.F. 08/06/12</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS	
		1- Machine as per Folio FA079	
		2- Tumble & Deburr	<u>J.L./J.F. 08/06/12</u>
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>J.L./J.F. 08/06/12</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>J.L./J.F. 08/06/12</u>
5.0	POWDER COATING	POWDER COATING	

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

\*\*\*\*\*Mask Inside Surface as per Dwg D2940\*\*\*\*\*

START TIME: 7:05 AMOVEN TEMPERATURE: 400 °FFINISH TIME: 7:35 AM

08-06-20 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/05/2008 4:10:33 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 39390

Part Number: D29401

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

MF 08 07 07

x20

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RT 08-07-11

x20

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 08-07-11

x20

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>39390</i>
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.151	.150	.151	.151	.151
AD	3.510	3.530		3.515	3.525	3.521	3.522	3.524
AE	1.633	1.673		1.657	1.658	1.657	1.657	1.665
AF	1.493	1.513		1.510	1.505	1.503	1.501	1.505
AG	0.040	0.060		.055	.049	.048	.049	.048
AH	0.188	0.193		.190	.190	.190	.190	.190
AI	0.140	0.160		.151	.150	.150	.150	.147
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.051	.050	.050	.050	.050
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.153	.148	.152	.148	.147
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.150	.150	.151	.151	.156
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.265	.263	.263	.264	.263
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.129	4.127	4.128	4.128	4.132
AV								
AW								
Accept/Reject								

Measured by: *JL* Date: *08/06/05*

Audited by: *JL* Date: *08/06/18*

Prototype Approval: Date: *[Signature]*

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	39390
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.240	0.260		250	250	250	R.250"	R.250"
AB	0.490	0.510		.500	.500	.500	A.500"	A.500"
AC	0.140	0.160		.154	.152	.152	.153"	.153"
AD	3.510	3.530		3.525	3.525	3.525	3.525"	3.525"
AE	1.633	1.673		1.660	1.660	1.657	1.660"	1.660"
AF	1.493	1.513		1.502	1.504	1.501	1.503"	1.503"
AG	0.040	0.060		.048	.049	.048	.049"	.049"
AH	0.188	0.193		.190	.192	.196	.189"	.189"
AI	0.140	0.160		.146	.147	.147	.151"	.151"
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		.050	.052	.049	.040"	.040"
AL	0.010	0.020		.015	.015	.015	.015"	.015"
AM	0.140	0.160		.149	.147	.150	.160"	.160"
AN	0.350	0.450		.390	.390	.370	.370"	.370"
AO	0.240	0.260		.250	.250	.250	.250"	.250"
AP	0.150	0.170		155	155	155	.155	.155
AQ	0.053	0.073		.063	.063	.063	.063"	.063"
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64"
AS	0.260	0.267		.264	.264	.264	.262"	.262"
AT	0.053	0.073		.063	.063	.063	R.063"	R.063"
AU	4.118	4.138		4.136	4.130	4.130	4.134"	4.134"
AV								
AW								
Accept/Reject								

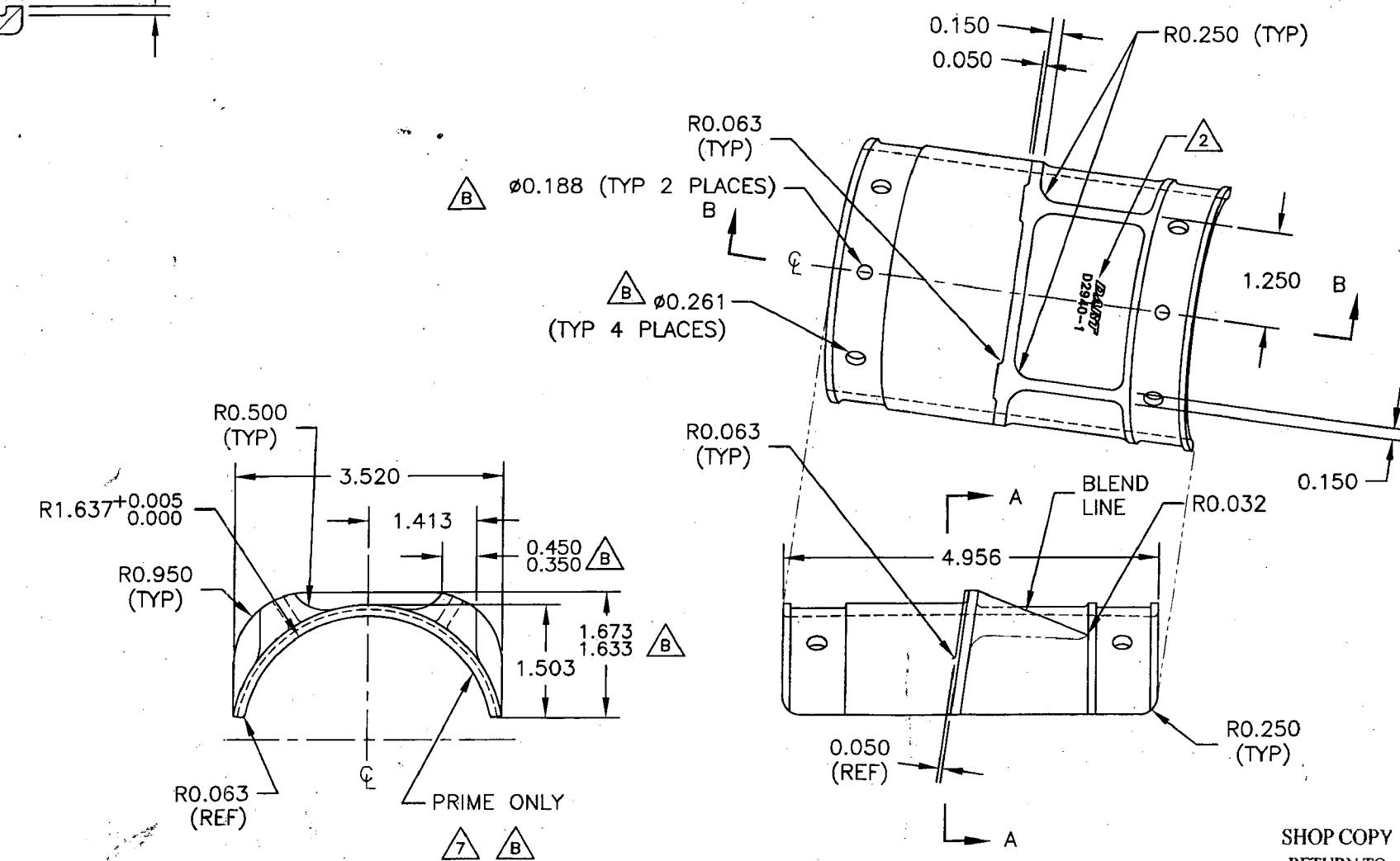
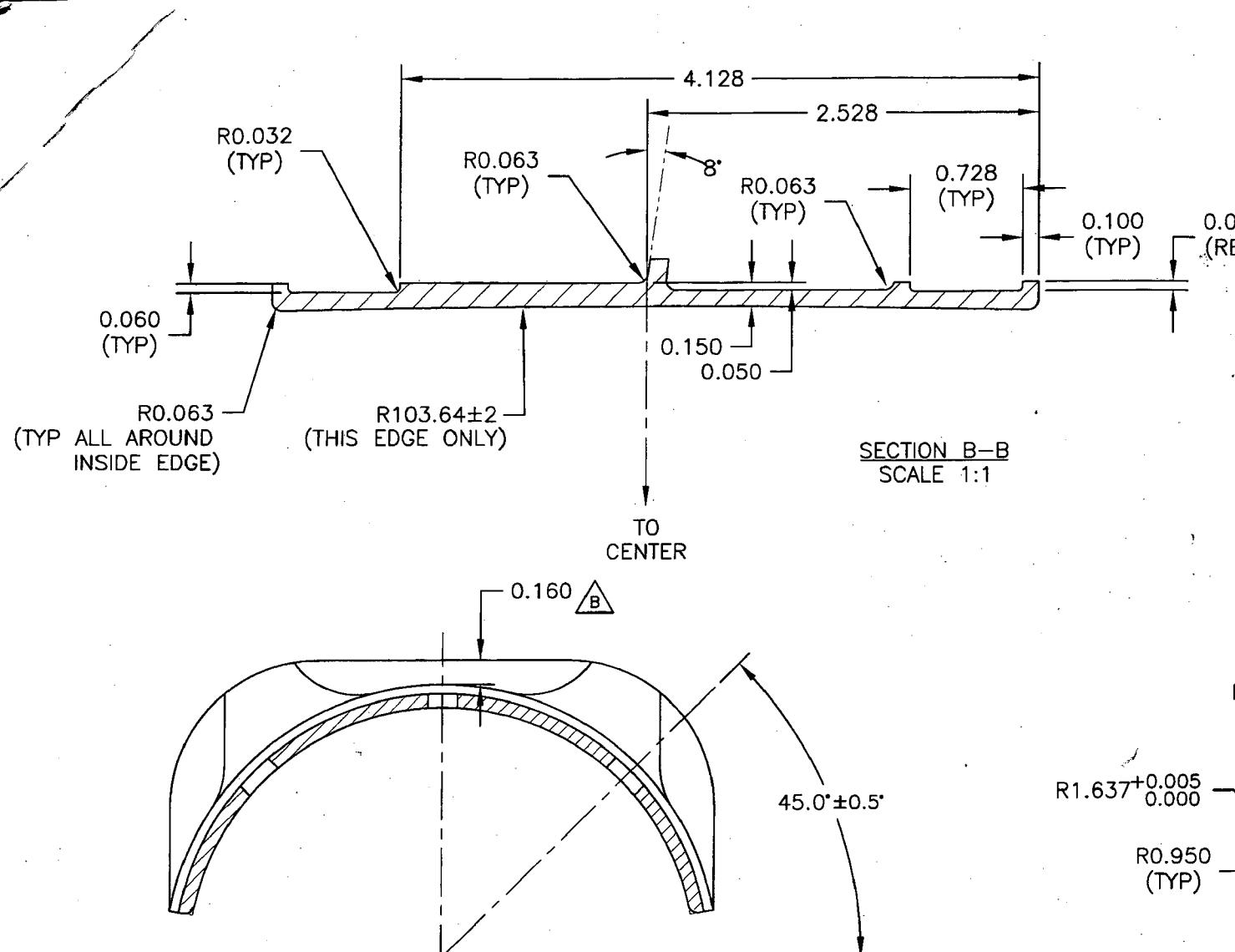
Measured by: *ML/J-F* Date: 08/06/08

Audited by: *JML* Date: 08-08-18

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev.	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>JML</i> <i>JML</i>

RELEASED  
67-04-24 (P)  
PER ECN 849



D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA  
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2940
DATE		SCALE 1:2
07.03.16		03.250 SUPPORT

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NO. 39390